

Work Order ID 150190

Wednesday, August 24, 2016 11:49:42 AM

150190

Page 1

Item ID: D3763-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube

Start Date: 8/18/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: **AUG 25 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3763	Rev B

100

0.00

100

Doosan

DOOSAN LATHE

Memo

0.18

Doosan Lathe

1- Turn as per Folio FA751 Rev: **AA** & Dwg D3763 Rev: **B** 2-Deburr per dwg D3763

10

0

DAS
45

9-89

2016-9-8

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

Quality Control

10

0

DAS
45

9-89

2016-9-8

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.02

Quality Control

10

SL 16-9-10

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

Work Order ID 150190

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Page 2

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Accept

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Revision ID:

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Item Name: Tube

Start Date: 8/18/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.01

LOCATION WA002

Packaging

10 DAS
9-89

SEP 13 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-8916/9/13
SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
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OTHER : _____					

Picklist Print

Wednesday, August 24, 2016 11:49:45 AM

Page 1

Work Order ID: 150190

150190

Parent Item: D3763-3

D3763-3

Parent Item Name: Tube

Start Date: 8/18/2016

Required Date: 8/24/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-23 new issue DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased			No	100	f	13.7880	0.109	0.688421			

M6061T6R1 250

6061-T6 Round Bar 1.250

Location

Loc Qty

Loc Code

MAT012

13.788

m131891

13.788

1,435

DAS

45

9-89

2016-9-8

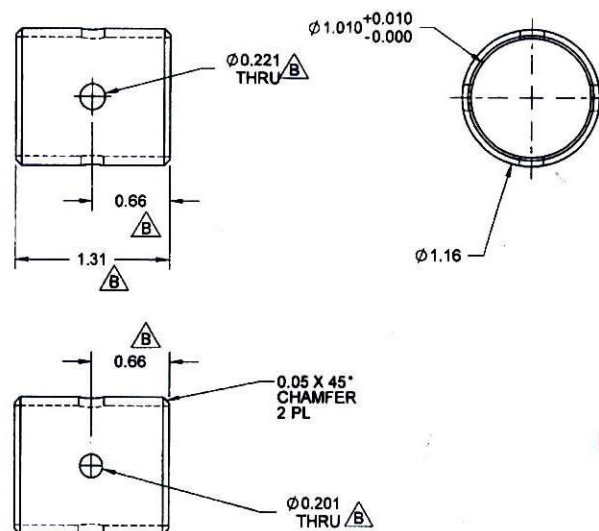
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

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D3763-3 TUBE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150190 ML
160825

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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